

SHIP Friday July 24

## Work Order ID 50786

July 22, 2009 12:47:27 PM

Page 1

Item ID: D3945-041

Accept

Revision ID: A

Item Name: Bracket

Setup Start

Stop

Start Date: 07/22/2009 Start Qty: 16.00

Required Date: 07/27/2009 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *mt*

Date: 09-07-23

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3945

A

100

0.00



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3945-1

Dwg Rev: AProg Rev: A

2-Deburr if necessary

0.00

IB

9-7-23

9/09/07/23 (30)

(30)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

IB 9-7-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

\* NOTE: Date & initial all entries

# Work Order ID 50786

July 22, 2009 12:47:27 PM

Page 2

Item ID: D3945-041

Accept

Setup Start

Revision ID: A

Stop

Item Name: Bracket

Start Date: 07/22/2009 Start Qty: 16.00

Cust Item ID:

Required Date: 07/27/2009 Req'd Qty: 16.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

QC8- Inspect parts - second check

0.00

⇒ 5 or less

counted  
+32

φ

QC

Memo

0.00

Quality Control

130

0.00

Small Fab

Memo

0.00

Small Fab

COUNTERSINK AS PER DWG

9/30/09/07/23

30

140

0.00

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg

8/29/07/23

30

φ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 50786

July 22, 2009 12:47:27 PM

Page 3

Item ID: D3945-041

Accept

Revision ID: A

Item Name: Bracket

Setup Start

Stop

Start Date: 07/22/2009 Start Qty: 16.00

Required Date: 07/27/2009 Req'd Qty: 16.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control



27 50786/23 (430) f P12 ->

M-h 09/07/23 (307) 28

BR 09-07-23 (307) 28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3945-041 PAR #: NA Fault Category: Finishing NCR: Yes No DQA: NA Date: 09.07.27  
Scrap / Scrap QA: N/C Closed: NA Date: 05.08.20

NCR: <u>50786</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/7/23	150 160	two parts lost between QC inspection to chemical coat.		Look in inspection area and Alodine area to ensure parts are not there	 07/07/23	09.07.23		 07/07/23
		R.C. wrong tank (big one used) Process.		Parts are not found - Use small alodine tank for small parts. Makes it easier to find them	M.H. 04/07/23	07/07/23		 07/07/23

NOTE: Date & initial all entries

# Work Order ID 50786



Page 4

July 22, 2009 12:47:27 PM

Item ID: D3945-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Bracket

Start Date: 07/22/2009 Start Qty: 16.00



Cust Item ID:

Required Date: 07/27/2009 Req'd Qty: 16.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

CP 09/07/23 28  
(30)

190

Memo

0.00



Small Fab

INSTALL NUT PLATES AS PER DWG

0.00

Small Fab

CP 09/07/23 28  
(30)

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2) S 09/07/03 counter  
(28) 6

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_/\_\_\_\_/\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Work Order ID 50786

July 22, 2009 12:47:27 PM

Page 5

Item ID: D3945-041

Accept

Revision ID: A

Item Name: Bracket

Start Date: 07/22/2009 Start Qty: 16.00

Required Date: 07/27/2009 Req'd Qty: 16.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Stop

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

210

Identify as per dwg & Stock Location: 137

0.00



Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

06/24/24 (30)

09/07/27

h 09-07-24

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

July 22, 2009 12:47:27 PM

Page 1

Work Order ID: 50786

Parent Item: D3945-041RevA

Parent Item Name: Bracket


Comments:

Start Date: 07/22/2009

Required Date: 07/27/2009

Start Qty: 16.00

Required Qty: 16.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	90.4649	0.1987			
												
6061-T6 .050 Sheet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

90.4648704

104186

-1.1988103

110791

89.6636807

17349

2

MS21059L3

Purchased

No

180

Each

839.0000

16.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

839

109962

339

111925

500

MS20426AD3-3

Purchased

No

180

Each

8,118.000

32.0000



Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8118

1563

0

19099

4776

7681

3342

110791 18 9-7-23

8/20/09/07/23

30

8/20/09/07/23

60

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

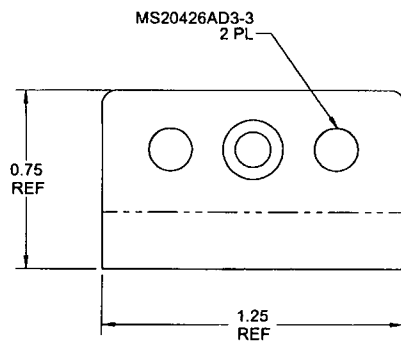
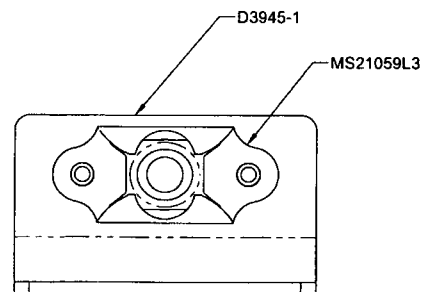
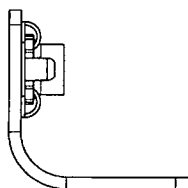
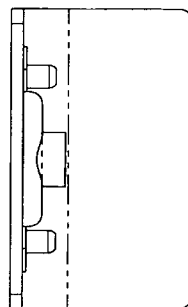
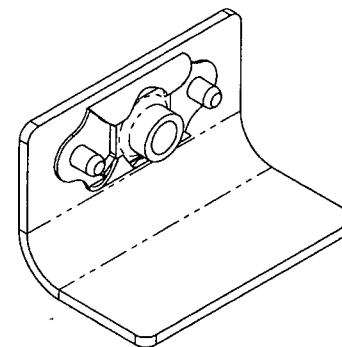
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## PARTS LIST

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET

**D3945-041 BRACKET**

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION		BY DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3945	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
09.05.01			
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

RELEASED  
29/06/16

# Dart Aerospace Ltd

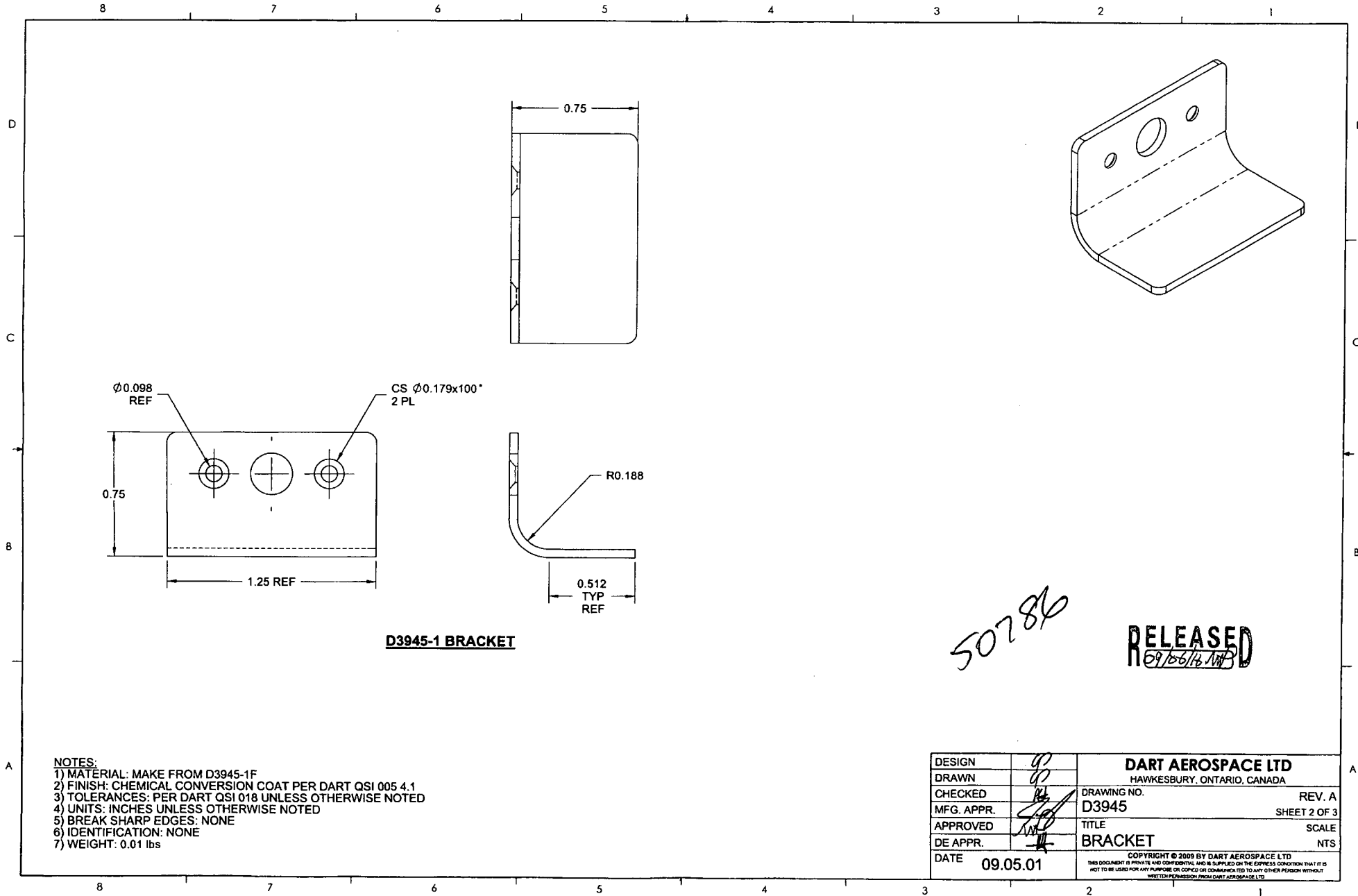
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



- NOTES:
- 1) MATERIAL: MAKE FROM D3945-1F
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: NONE
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.01 lbs

DESIGN	93	<b>DART AEROSPACE LTD</b>	
DRAWN	93	HAWKESBURY, ONTARIO, CANADA	
CHECKED	93	DRAWING NO.	REV. A
MFG. APPR.	93	D3945	SHEET 2 OF 3
APPROVED	93	TITLE	SCALE
DE APPR.	93	BRACKET	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

50786

RELEASED  
09/06/14



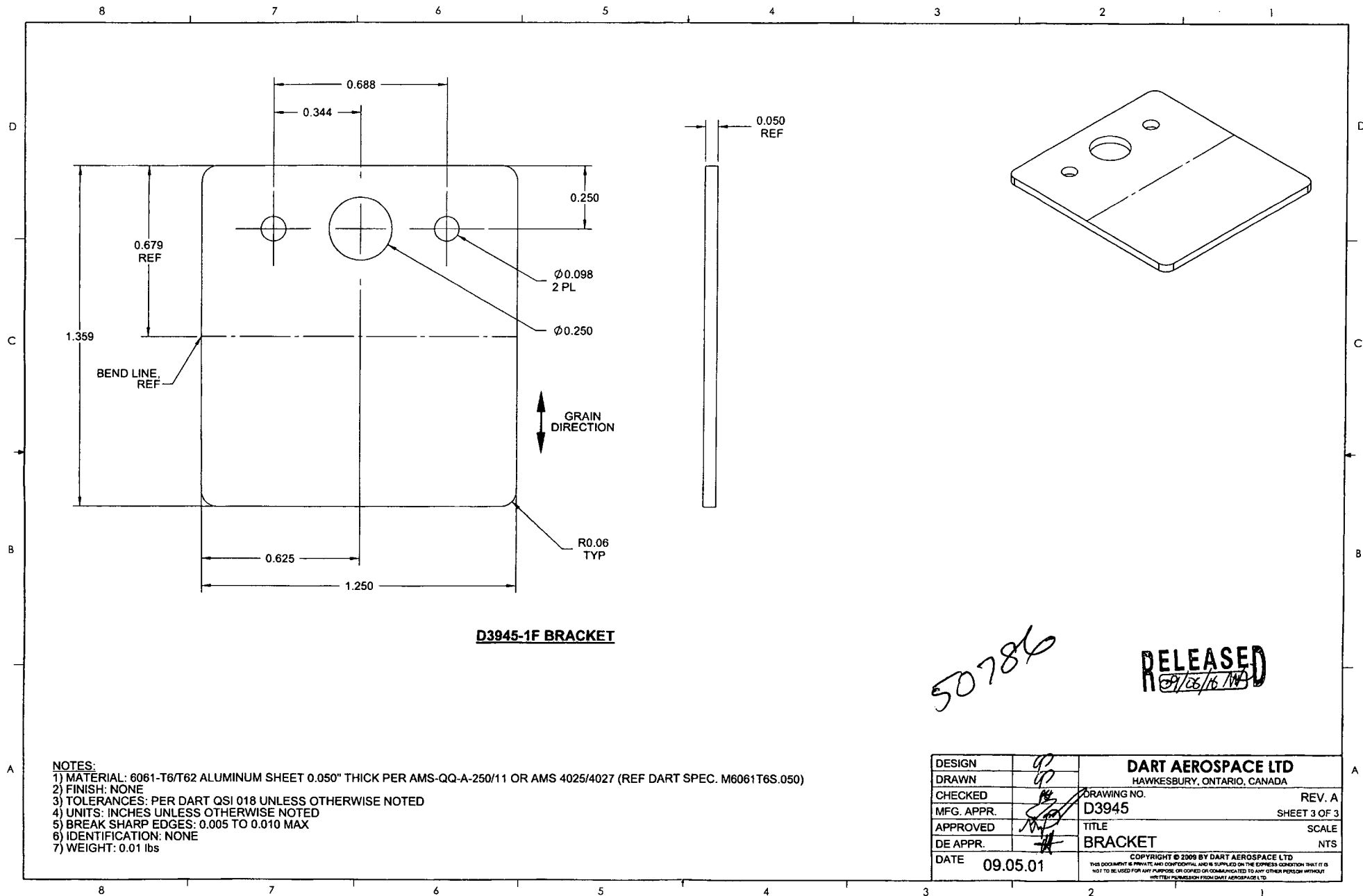
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries